

Date: Friday, 01/02/2008 12:51:02 PM
User: Jean-Luc Menard



Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 37146		
Estimate Number	: 11125		
P.O. Number	:	Part Number	: D34033
This Issue	: 01/02/2008 S.O. No. :	Drawing Number	: D3403 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 35635	Material	:
Written By	: <u>08.02.01</u>	Due Date	: 08/02/2008 Qty: 39 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A 05.08.31 New issue KJ/JLM Est Rev:B 06-03-07 As per Rev B JLM		

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	M303R0750	303 Round Bar .75"
		

Comment: Qty.: 0.1833 f(s)/Unit Total : 7.3320 f(s)
Material: AISI 303 SS Bar Ø0.750
(M303R0.750)
Identify for D3403-3
Batch: M106633

H.A

39

08/02/03

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		

Comment: HARDINGE CNC LATHE SMALL

1- Turn as per Folio FA558 & Dwg D3403
Folio Rev: AA Dwg Rev: B

2-Deburr

H.A/gml

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08/02/03


3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A/gml


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08/02/03

4.0	QC8	SECOND CHECK
		

Comment: SECOND CHECK

08.02.04 39

5.0	PACKAGING 1	PACKAGING RESOURCE #1
		

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST91

AS 08/02/06

39

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 37146

Part Number: D34033

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



39

Comment: FINAL INSPECTION/W/O RELEASE

2008/02/07

Job Completion



2008/2/06

39

W

DART AEROSPACE LTD		Work Order: 37146
Description: Bushing		Part Number: D3403-3
Inspection Dwg: D3403	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.165	+0.010/-0.000	2.1685	✓			
0.060	+/-0.005	0.061	✓			
Ø0.257	+0.005/-0.000	Ø0.262	✓			
Ø0.750	+/-0.010	Ø.747	✓			
Ø0.425	-0.000/0.002	Ø.424	✓			
Ø.313 x 60°	+/- .010 / +/- 1/2°	Ø.315 x 60°	✓			
R0.010	+/- .010	R0.010	✓			

Measured by: H.A/gm	Inspected by: [Signature]	Prototype Approval: N/A
Date: 08/02/03	Date: 08-02-03	

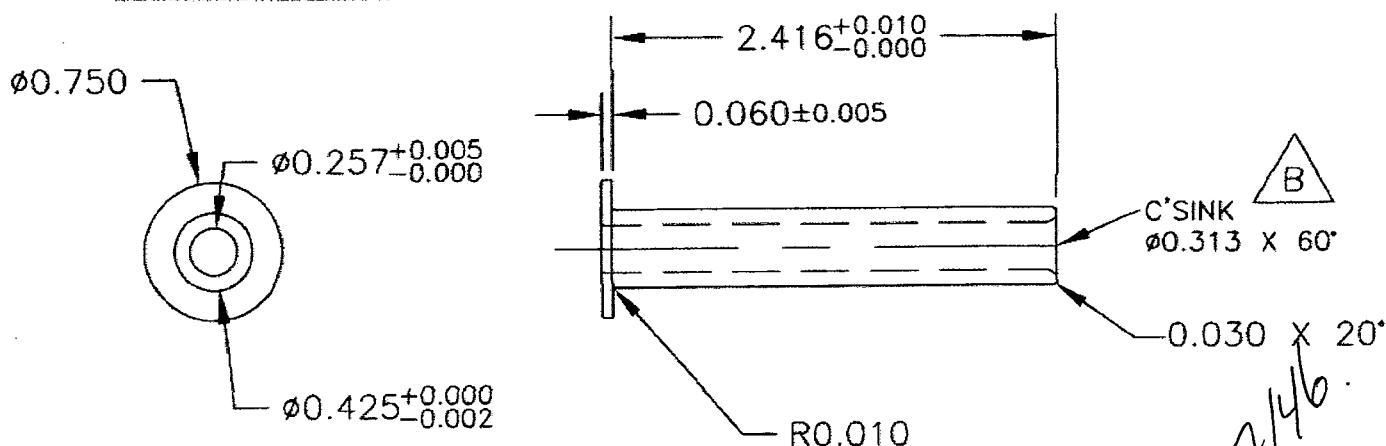
Rev	Date	Change	Revised by	Approved
1	08-02-03	Initial Issue	[Signature]	[Signature]



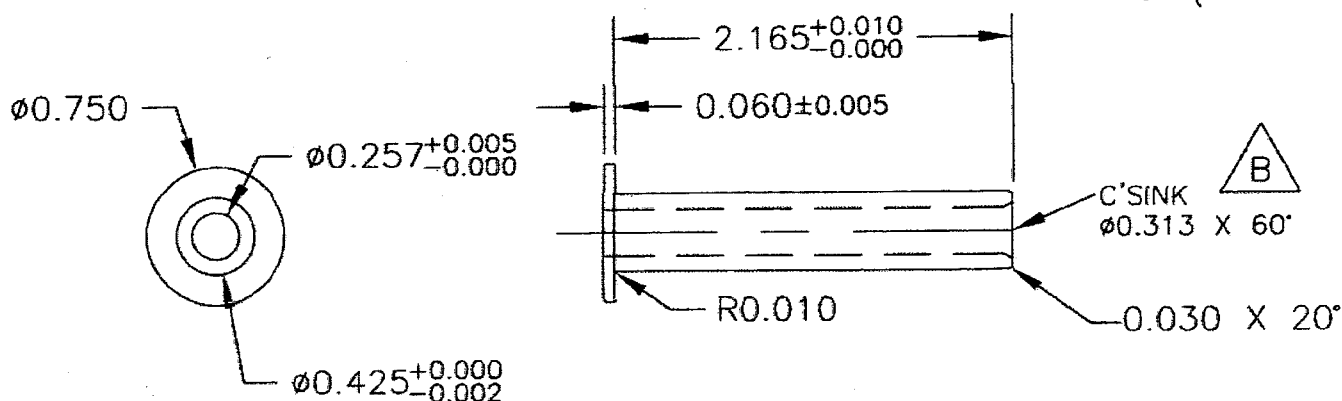
DESIGN	DRAWN BY	DART AEROSPACE LTD	
PH	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
#	#	D3403	SHEET 1 OF 1
DATE		TITLE	SCALE
06.01.23		BUSHING	1:1
A	05.03.07	NEW ISSUE	
B	06.01.23	ADD COUNTERSINK	

RELEASED

06.01.23



D3403-1 BUSHING



D3403-3 BUSHING

D3403-1/-3 BUSHING

- 1) MATERIAL: $\phi 0.750$ AISI 303 ROUND BAR (REF. DART SPEC. M303R0.750)
- 2) FINISH: NONE
- 3) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX
- 4) ALL DIMENSIONS ARE INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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